

DART AEROSPACE LTD		Work Order: 40063
Description: Crosstube Assembly BEARING		Part Number: B67-43001-305
Inspection Dwg:	Rev: B1	Page 1 of 1

pg. 41.

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	.750	+0.008 - .001	.755			
	1.820	+/- .010	1.821			
	1.200	+/- .010	1.261			
	2.00	+/- .030	2.000			
	2.50	+/- .030	2.510			
	.250	+/- .010	.251			
	1.50	+/- .030	1.500			
	.40	+/- .030	.396			
	.313	+ .006 - .001	.314			
	1.75	+/- .030	1.75			
SIDE B						

Measured by: 29	Audited by: J.L	Prototype Approval:	N/A
Date: 08/07/08	Date: 08/07/08	Date:	N/A
Rev A	Date	Change	Revised by
		New Issue	KJ/JLM
			Approved

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

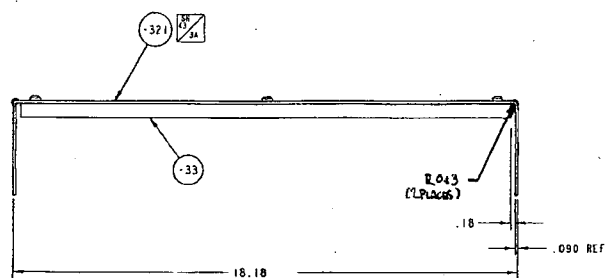
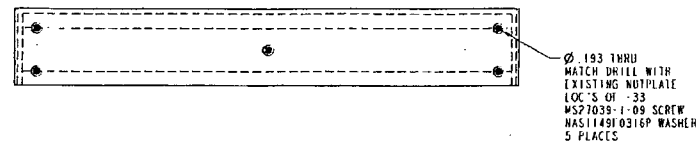
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

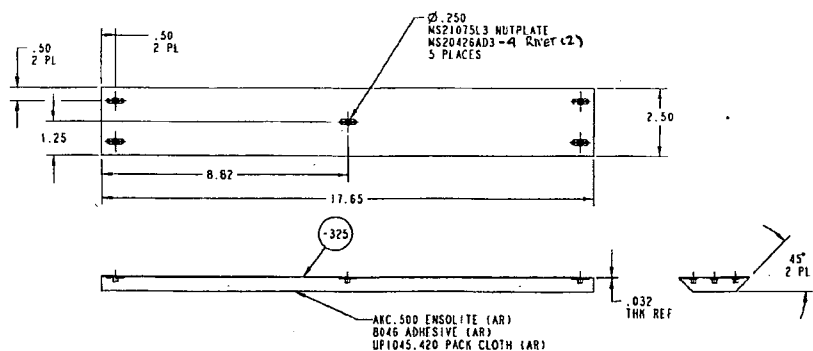
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
400602

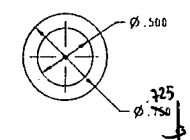
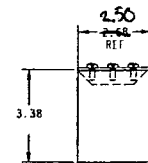
RELEASED
06-01-20



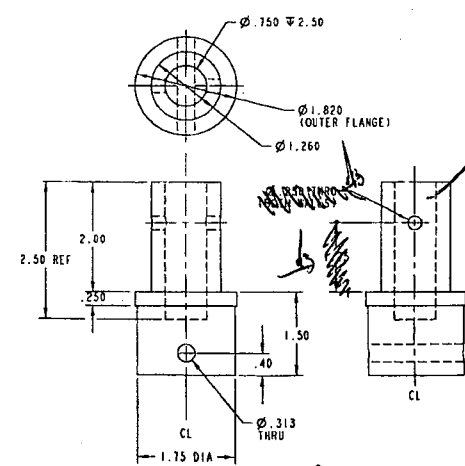
① -31 UPPER RESTRAINT WELDMENT
SCALE 0.500



① -33 UPPER PAD ASSY
SCALE 0.500
MATERIAL FOR -325: .032 THK 2024-T3 AL.
QQ-A-250/J4



④ -299 BUSHING
SCALE 2.000
MAT: 304 CRES. COND A



④ -305 BEARING
SCALE 1.000
MAT: 2024-T3 AL.
QQ-A-200/J3

PREMIER AVIATION, INC.			
3001 Aviation Parkway, Grand Prairie, Texas 75052			
DATE	CODE (REV) NO.	QRP NO.	REV
D10SUVB	867-43001		1
SCALE	QTY	PRICE	AMOUNT
			45

ORIGINAL

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 40063

Part Number: PB6743001305

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



mo 23/6



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3
Mask Ø1.260"

START TIME:

11h30

OVEN TEMPERATURE:

320

FINISH TIME:

12:00

BL / 212 08/07/10

(62)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/10

(6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Pat F.

MF

08-0714

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/15

Job Completion



MF 08-07-14

Date: Wednesday, 25/06/2008 2:37:04 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING
Job Number : 40063	
Estimate Number : 12075	
P.O. Number :	Part Number : PB6743001305
This Issue : 25/06/2008 S.O. No. :	Drawing Number : B6743001 PAGE41
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 40063	Material :
Written By : <i>JLM 06.02.25</i>	Due Date : 02/07/2008 Qty: 8 Um: Each
Checked & Approved By :	
Comment : Est. A 05.07.20 New issue KJ/JLM	
Est Rev:B Now on Doosan Lathe 08-06-25 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3R1750 <i>1.875</i>	2024-T3 Round Bar 1.750"
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Comment: Qty.: 0.3150 f(s)/Unit Total : 2.5200 f(s)

2024-T3 Round Bar ~~1.750~~ *1.875*Material: 2024-T3 Round Bar ~~1.750~~ *1.875*,
(M2024T3R1.750)

Identify for B67-43001-305

Batch: *M17892**RQ 08/07/08*

2.0	DOOSAN LATHE	DOOSAN LATHE
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Comment: DOOSAN

Turn as per Dwg B67-43001

Dwg Rev: *B1**RQ 08/07/08*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RQ 08/07/08 (6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/07/08

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*RQ / JL 08/07/08**(6)*